

Ship wedn. 6 jan 2010

Page 1

Work Order ID 54857

December 31, 2009 11:00:13 AM



Item ID: D205-770-011

Accept



Setup Start



Revision ID:

Item Name: Replacement Engine Mount

Stop



Start Date: 1/4/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 1/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: WIP

Date: 09-12-31 Tooling: _____ Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN D205-770	Rev B

100



DOCUMENT CONTROL

DC

Document Control

Memo

0.00

002

110



Pick Kit

0.00

Packaging

Packaging

Memo

0.00

120



QC4- 100% Inspect kits for completeness

0.00

QC

Quality Control

Memo

0.00

→ Scallop

(X)

Pto →

Scallop

Pto 10/10/09 C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/01/05	# 100	wp date chg to b chg 602. see Attached Ecn	M	10/01/05		J 10/01/05	S 10/01/05

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54857

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Item ID: D205-770-011

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Setup Start



Revision ID:

Item Name: Replacement Engine Mount

Stop



Start Date: 1/4/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 1/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

130

Operation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

Packaging

0.00

Identify and pack for shipping as per PPP D205-770-011 CHG001

Location: 42PPP Rev: 03

10-1-05

QD

140



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

1

10.01.05

MF

BB

10-01-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 31, 2009 11:00:12 AM

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Work Order ID: 54857



Parent Item: D205-770-011



Parent Item Name: Replacement Engine Mount

Start Date: 1/4/2010

Required Date: 1/6/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3684-043  MOUNT ASSEMBLY		Manufactured	No			110	Each	1.0000	1.0000			<i>PW</i>

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1

52470

1

Manufactured

No

110

Each

7.0000

1.0000

52470

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

5

50740

5

50740

Main Warehouse

ST139A

2

51152

1

52469

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 31, 2009 11:00:12 AM

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13

Work Order ID: 54857



Parent Item: D205-770-011



Parent Item Name: Replacement Engine Mount

Start Date: 1/4/2010

Required Date: 1/6/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3692-1 		Manufactured		No		110	Each	654.0000	4.0000 			<i>PJ</i>

SPACER

Warehouse

Location

Main Warehouse

ST	59	
44827	8	
45672	14	
50325	37	

Main Warehouse

ST127	595	
50736	187	
51467	408	

AN3C12A

Purchased

No

110

Each

356.0000

Bolts

Warehouse

Location

Main Warehouse

ST	356	
112314	356	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 31, 2009 11:00:12 AM

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Work Order ID: 54857



Parent Item: D205-770-011



Parent Item Name: Replacement Engine Mount

Start Date: 1/4/2010

Required Date: 1/6/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-3		Purchased		No		110	Each	4,548.000	2.0000			

Nut

Barcode for Nut

Warehouse

Location

OFFSHORE

FG 80

103691 80

Main Warehouse

ST 4468

111819 70

112243 29

112314 4369

D3685-041

Barcode for D3685-041

BIPOD MOUNT ASSEMBLY

D3686-041

Barcode for D3686-041

MONOPOD ASSEMBLY

Warehouse

Location

Main Warehouse

ST 2

51156 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54857

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Setup Start



Stop



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Start Date: 1/4/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 1/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
-------------	-----------	-----------	------------	------------	---------------	-------------

Draw Nbr

Revision Nbr

0.00

100



DOCUMENT CONTROL

0.00

DC

Memo

Photocopy bluefile and create labels per PPP D205-770-011 CHG001

BF 10-1-09

Document Control

110



Pick Kit

0.00

Packaging

Memo

0.00

Packaging

120



QC4- 100% Inspect kits for completeness

0.00

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4. WEIGHT AND BALANCE

The following is the net weight increase associated with the D205-770-011 Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-770-011 Replacement Engine Mount Kit	14.6 lb 6.62 kg	-3.5 in -0.09 m	-51.1 in-lb -0.6 m-kg	107.8 in 2.74 m	1574 in-lb 18.1 m-kg

5. PARTS LIST

Qty -011	Part Number	Description
X	D205-770-011	REPLACEMENT ENGINE MOUNT KIT
1	D3684-041	TRIPOD MOUNT ASSEMBLY
1	*D3684-043	MOUNT ASSEMBLY
8	**D3692-1	SPACER
4	**AN3C-12A	BOLT
4	**MS21043-3	NUT
1	**D3687-1	MOUNT
1	**D3684-047	FWD LEG ASSEMBLY
1	***D3688-1	STUD
1	***D3689-1	SLEEVE
1	***D3691-1	STUD
4	***D3692-1	SPACER
1	***D3693-1	ROD END BEARING
2	**AN3C-12A	BOLT
2	**MS21043-3	NUT
1	***NAS509-12C	NUT
1	***NAS509L-12C	NUT
1	**D3684-049	AFT LEG ASSEMBLY
1	***D3688-3	STUD
1	***D3689-1	SLEEVE
1	***D3691-1	STUD
4	***D3692-1	SPACER
1	***D3693-1	ROD END BEARING
2	**AN3C-12A	BOLT
2	**MS21043-3	NUT
1	***NAS509-12C	NUT
1	***NAS509L-12C	NUT
1	*D3684-045	INBOARD LEG ASSEMBLY
1	**D3688-5	STUD
1	**D3689-1	SLEEVE
1	**D3691-1	STUD
4	**D3692-1	SPACER
1	**D3693-1	ROD END BEARING
2	**AN3C-12A	BOLT
2	**MS21043-3	NUT
1	**NAS509-12C	NUT
1	**NAS509L-12C	NUT
4	*D3692-1	SPACER
2	*AN3C-12A	BOLT
2	*MS21043-3	NUT

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OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: B
Date: 08.12.15

1	D3685-041	BIPOD MOUNT ASSEMBLY
1	*D3687-3	MOUNT
1	*D3684-047	FWD LEG ASSEMBLY
1	**D3688-1	STUD
1	**D3689-1	SLEEVE
1	**D3691-1	STUD
4	**D3692-1	SPACER
1	**D3693-1	ROD END BEARING
2	**AN3C-12A	BOLT
2	**MS21043-3	NUT
1	**NAS509-12C	NUT
1	**NAS509L-12C	NUT
1	*D3684-049	AFT LEG ASSEMBLY
1	**D3688-3	STUD
1	**D3689-1	SLEEVE
1	**D3691-1	STUD
4	**D3692-1	SPACER
1	**D3693-1	ROD END BEARING
2	**AN3C-12A	BOLT
2	**MS21043-3	NUT
1	**NAS509-12C	NUT
1	**NAS509L-12C	NUT
8	*D3692-1	SPACER
4	*AN3C-12A	BOLT
4	*MS21043-3	NUT
1	D3686-041	MONOPOD ASSEMBLY
1	*D3688-7	STUD
1	*D3689-1	SLEEVE
1	*D3691-1	STUD
4	*D3692-1	SPACER
4	*D3692-3	SPACER
1	*D3693-1	ROD END BEARING
1	*D3693-3	ROD END BEARING
2	*AN3C-10A	BOLT
2	*AN3C-12A	BOLT
4	*MS21043-3	NUT
1	*NAS509-12C	NUT
1	*NAS509L-12C	NUT

(NOTE: PARTS IN BOLD TYPE CONSTITUTE PICK LIST FOR D205-770-011 KIT)

* PART IS INCLUDED WITH ASSEMBLY ABOVE

** PART IS INCLUDED WITH ASSEMBLY ABOVE

*** PART IS INCLUDED WITH ASSEMBLY ABOVE

ENGINEERING CHANGE NOTICE
DART AEROSPACE LTD

Date: 09.09.09	Job No.: ENG0108AGU	ADR Yes/No: Y	ADR Date: 09.08.26	ECN #: 09- 664
Product No.: D205-770		Created By: RF	Approved By: <i>[Signature]</i>	
Product Name: Replacement Engine Mount Kit		Checked By: <i>[Signature]</i>		General Manager Approval:

Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL/JLM	14.09.09.02
Production Engineering Coord	Y	EC/DD	14.09.09.22
Production Document Control	N		
Customer Technical Support	N		

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord	N		
QC Coordinator	N		
Marketing	N		
Customer Order Processing	N		

Reason for Change: Correct problem with D3687 per NCR09-084. Improvement for machining on D3688 & D3691

Documents Affected:

Release of the following documents:

MDL-D205-770 Rev. D

D3687 Rev. C

D3688 Rev. C

D3691 Rev. C

REFERENCE ONLY

PARTS MUST COMPLY

PREVIOUS PARTS SATISFACTORY

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	Y	KJ		09.09.22 <i>[Signature]</i>
9	Update Blue/Pink/DSI Folder and Electronic Files	N			
10	Update Controlled PDF Files	Y	KJ		09.09.22 <i>[Signature]</i>
11	Update Master Document List (MDL)	Y	RF	MDL-D205-770 Rev. D	<i>[Signature] RF 09.09.22</i>
12	Update Document Record (DR)	Y	KJ	<i>Rev. C</i>	09.09.22 <i>[Signature]</i>
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	N			
16	Update / Verify ARC Database	N	KJ		
17	Create / Update Change Record Form	Y	KJ	D205-770-011 now at CHG 002-1	09.09.22 <i>[Signature]</i>
18	Create / Update PPP's	Y	KJ		09.09.22 <i>[Signature]</i>
19	Update Document Control Database / Laminated Dwgs	N	KJ		
20	Update Grey Project Binder	Y	KJ		09.09.22 <i>[Signature]</i>
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		09.09.22 <i>[Signature]</i>
22					
23					

Description / Action:

Send D3687 Rev. C drawing to vendor to update CNC program for D3687-1/-3. Existing Stock has been fixed per D. Shepherd instructions (see ADR dated 09.08.26). Update internal CNC program per D3688 and D3691 Rev. C. Existing stock done with previous revision are ok.

ECN Verified & Complete: *[Signature]*

Date: 09/09/22

ENGINEERING CHANGE NOTICE
DART AEROSPACE LTD

Date: 09.09.09	Job No.: ENG0108AGU	ADR Yes/No: Y	ADR Date: 09.08.26	ECN #: 09- 664
Product No.: D205-770		Created By: RF	Approved By: <i>[initials]</i>	
Product Name: Replacement Engine Mount Kit		Checked By: <i>[initials]</i>		General Manager Approval:

Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	KJ/JLM	
Production Engineering Coord	Y	EC/DD	
Production Document Control	N		
Customer Technical Support	N		

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord	N		
QC Coordinator	N		
Marketing	N		
Customer Order Processing	N		

Reason for Change: Correct problem with D3687 per NCR09-084. Improvement for machining on D3688 & D3691

REFERENCE ONLY

Documents Affected:
Release of the following documents:
MDL-D205-770 Rev. D
D3687 Rev. C
D3688 Rev. C
D3691 Rev. C

PARTS MUST COMPLY

PREVIOUS PARTS SATISFACTORY

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	Y	KJ		09.09.22 <i>[initials]</i>
9	Update Blue/Pink/DSI Folder and Electronic Files	N			
10	Update Controlled PDF Files	Y	KJ		09.09.22 <i>[initials]</i>
11	Update Master Document List (MDL)	Y	RF	MDL-D205-770 Rev. D	09.09.22 <i>[initials]</i> RF 09.09.22
12	Update Document Record (DR)	Y	KJ	Rev. C	09.09.22 <i>[initials]</i>
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	N			
16	Update / Verify ARC Database	N	KJ		
17	Create / Update Change Record Form	Y	KJ	D205-770-011 now at CHG 002-1	09.09.22 <i>[initials]</i>
18	Create / Update PPP's	Y	KJ		09.09.22 <i>[initials]</i>
19	Update Document Control Database / Laminated Dwgs	N	KJ		
20	Update Grey Project Binder	Y	KJ		09.09.22 <i>[initials]</i>
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		09.09.22 <i>[initials]</i>
22					
23					

Description / Action:

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Update internal CNC program per D3688 and D3691 Rev. C. Existing stock done with previous revision are OK.

[Signature]

ECN Verified & Complete: _____ Date: _____